

<b>METRIC</b>
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**A-A-20158D**  
**March 28, 2005**  
**SUPERSEDING**  
**A-A-20158C**  
**May 21, 2004**

## **COMMERCIAL ITEM DESCRIPTION**

### **SALMON, CANNED OR IN FLEXIBLE POUCHES**

**The U.S. Department of Agriculture (USDA) has authorized the use of this Commercial Item Description (CID).**

**1. SCOPE.** This CID covers canned or flexible pouched salmon, packed in commercially acceptable containers, suitable for use by the Federal, State, local governments, and other interested parties, and as a component of operational rations.

#### **2. PURCHASER NOTES.**

##### **2.1 Purchasers *shall specify* the following:**

- Type(s), specie(s), style(s), and salt/sodium level(s) required (Sec. 3).
- When analytical requirements are different than specified (Sec. 6.1).
- When analytical requirements need to be verified (Sec. 6.2).
- Manufacturer's/distributor's product assurance (Sec. 7).
- Manufacturer's/distributor's certification (Sec. 9.2) or U.S. Department of Commerce (USDC) certification (Sec. 9.3).
- Product examination: For USDA Procurements Only (Sec. 9.4).

##### **2.2 Purchasers *may specify* the following:**

- Manufacturer's quality assurance (Sec. 9.1).
- Packaging requirements other than commercial (Sec. 10).

**3. CLASSIFICATION.** The salmon shall conform to the following list which shall be specified in the solicitation, contract, or purchase order.

#### **Types, species, styles, and salt/sodium levels.**

**Type A** - Can

**Type B** - Flexible retort pouch

**FSC 8905/8940**

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<b>Species I</b>	- Oncorhynchus tshawytscha	- Chinook, king, spring
<b>Species II</b>	- Oncorhynchus nerka	- Blueback, red, sockeye
<b>Species III</b>	- Oncorhynchus kisutch	- Coho, coho, medium red, silver
<b>Species IV</b>	- Oncorhynchus gorbuscha	- Pink
<b>Species V</b>	- Oncorhynchus keta	- Chum, keta

**Style a** - Regular - skin and bones included

**Style b** - Special - skinless and backbone removed

**Style c** - Pouch - deep skinned and boneless (pin bones may remain in)

**Salt/sodium level 1** - Regular (no more than 1.5 percent salt)

**Salt/sodium level 2** - No salt added (no sodium chloride added during processing)

**Salt/sodium level 3** - Very low sodium (35 milligrams or less sodium per serving)

**Salt/sodium level 4** - Low sodium (140 milligrams or less sodium per serving)

### **4. MANUFACTURER'S/DISTRIBUTOR'S NOTES. Manufacturer's/distributor's products *shall meet the requirements of the:***

- Salient characteristics (Sec. 5).
- Analytical requirements: *as specified by the purchaser* (Sec. 6).
- Manufacturer's/distributor's product assurance (Sec. 7).
- Regulatory requirements (Sec. 8).
- Quality assurance provisions: *as specified by the purchaser* (Sec. 9).
- Packaging requirements other than commercial: *as specified by the purchaser* (Sec. 10).

### **5. SALIENT CHARACTERISTICS.**

**5.1 Standard of Identity.** The canned salmon shall meet the requirements of 21 CFR § 161.170, Canned Salmon.

**5.2 Processing.** The salmon shall be prepared in accordance with 21 CFR Part 110, Good Manufacturing Practices, 21 CFR Part 113, Thermally Processed Low-Acid Foods Packaged in Hermetically Sealed Containers, 21 CFR Part 123, Fish and Fishery Products, and be commercially sterile, ready-to-use.

**5.3 Raw ingredients.** Only current season, fresh or RSW (Refrigerated Sea Water) salmon shall be used for canned product. The fresh or RWS water may include unintentionally partially frozen salmon. Current season fresh or frozen salmon shall be used for pouch product. The product shall be derived from raw material having characteristics that are indicative of good quality salmon. These include, but are not limited to, firmness and color of flesh typical of the species, and no off-odor of the gills and gut cavity. The washed salmon prior to packing in the primary container shall be free of objectionable materials, including but not limited to, heads,

gills, tails, viscera, blood marks, bruising, collar cartilage and fins. Heavily watermarked (watermarked salmon that has an impact of flavor, odor, and appearance) and hatchery brood stock shall not be used.

In addition to the above, the pouch salmon shall be free of rib bones and vertebrae. The salmon fillets shall be deep skinned and boneless (pin bones may remain in).

**5.4 Seasonings/seasonings.** The canned salmon shall contain only salmon and salt as specified in Sec. 3. At a minimum, the pouch salmon shall be comprised of 95 percent deep skinned and boneless (pin bones need not be removed) salmon fillets. Pouch salmon may either be a natural product with vegetable broth added or may contain spices, seasonings, artificial colors, and other ingredients as needed to produce a consistent flavor, odor, texture and color as specified by the solicitation, contract, or purchase order. The pouch salmon shall contain no monosodium glutamate.

## **5.5 Finished product.**

**5.5.1 Color and texture.** The color of the oil, flesh and the texture of the finished product shall be in accordance with Table I below.

**TABLE I. Finished Product characteristics**

<b>Species</b>	<b>Color of oil</b>	<b>Color of flesh</b>	<b>Texture of fish</b>
Chinook, king, spring	Light red through orange to almost white	Red to orange red to light pink	Moderately firm to soft
Blueback, red, sockeye	Deep red to deep orange	Dark red to orange red	Moderately firm to soft
Coho, coho, medium red, silver	Light red to yellowish pink	Red to orange red to light pink	Moderately firm to soft
Pink	Pink to light yellow	Pink to Buff	Moderately firm to slightly soft (but not mushy)
Chum, keta	Light pink with orange shade to yellow	Light pink to grayish white	Moderately firm to firm

**5.5.2 Odor and flavor.** The canned and/or pouched salmon shall have an odor and flavor typical of the species that have been subjected to proper handling and good manufacturing

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practices.

**5.6 Foreign material.** There shall be no foreign material such as, but not limited to, struvite crystals, dirt, insects, insect parts, hair, wood, glass, or metal.

## 6. ANALYTICAL REQUIREMENTS.

**6.1 Analytical requirements.** Unless otherwise specified in the solicitation, contract, or purchase order, analytical requirements for the salmon shall be as follows:

Salt/sodium level 1	Not more than 1.5 percent salt
Salt/sodium level 2, 3, 4	Must not exceed limits specified in 21 CFR § 101.61

**6.2 Product verification.** When USDC verification of analytical requirements is specified in the solicitation, contract, or purchase order, the following procedures will be followed.

**6.2.1 Sampling procedures.** USDC inspection service will select the number of product containers based on agency inspection service sampling procedures and plans.

**6.2.2 Samples.** Analytical testing for salt and sodium shall be performed on a composite sample. The composite sample shall be 680 g (24 oz). The minimum number of 12 sample units shall be used for deriving the composite sample. The sample units shall represent all the codes selected for product evaluation. Equal amounts of product will be taken from each selected sample unit and from each code. If the sample size is too small to provide for sampling of all codes, more sample units may be selected with less product taken from each can or pouch.

**6.3 Analytical testing.** Analytical testing shall be in accordance with the following methods from the Official Methods of Analysis of the AOAC International.

<u>Test</u>	<u>Method</u>
Salt	937.09, 976.18, or 976.19
Sodium	969.23

**6.4 Test results.** The test results for salt shall be reported to the nearest 0.1 percent, sodium to the nearest mg per 100 g. Any test result not conforming to the analytical requirements shall be cause for rejection of the lot.

## **7. MANUFACTURER'S/DISTRIBUTOR'S PRODUCT ASSURANCE.**

**7.1 FOR NON-USDA PROCUREMENTS.** The manufacturer/distributor shall certify that the salmon products provided shall meet the salient characteristics of this CID, conform to their own specifications, standards, and quality assurance practices, and be the same salmon products for sale in the commercial market. The purchaser reserves the right to require proof of conformance.

**7.2 FOR USDA PROCUREMENTS ONLY.** When specified in the solicitation, contract, or purchase order, the manufacturer/distributor shall warrant that the salmon products provided shall comply with all specification requirements, technical proposal declarations, and provisions set forth in the solicitation, contract, or purchase order. All customer complaint resolution procedures shall be included in the technical proposal. These procedures shall include: a point of contact, investigation steps, intent to cooperate with the purchaser, and product replacement or monetary compensation. The procedures will be used to resolve product complaints from the recipient agencies or the purchaser.

**8. REGULATORY REQUIREMENTS.** The delivered salmon products shall comply with all applicable Federal, State, and local mandatory requirements and regulations relating to the preparation, packaging, labeling, storage, distribution, and be the same salmon products offered for sale within the commercial marketplace. Delivered salmon products shall comply with all applicable provisions of the Federal Food, Drug, and Cosmetic Act, the Fair Packaging and Labeling Act, and regulations promulgated thereunder.

**9. QUALITY ASSURANCE PROVISIONS.** *Purchaser shall specify 9.2 or 9.3; (9.1 is optional when 9.2 is specified).* The USDC requires 9.1 when 9.3 is specified.

**9.1 Manufacturer's quality assurance.** When required in the solicitation, contract, or purchase order, the product manufacturer shall be required to have their facilities inspected by USDC and be eligible for listing in the USDC publication, "USDC Participants List for Firms, Facilities and Products." (USDC sanitation inspections verify that, at the time of the inspection, the manufacturer demonstrated their ability to meet rigid standards of sanitation and are capable of producing safe, wholesome salmon products).

**9.2 Manufacturer's/distributor's certification.** When required in the solicitation, contract, or purchase order, the manufacturer/distributor will certify that the finished salmon products meets or exceed the requirements of this CID.

**9.3 USDC certification.** When required in the solicitation, contract, or purchase order that product quality or acceptability or both be determined, USDC shall be the certifying program. USDC inspectors shall certify the quality and acceptability of the salmon products in accordance with USDC procedures which include selecting random samples of the packaged salmon products, evaluating the samples for conformance with the salient characteristics of this CID and

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other contractual requirements, and documenting the findings on official USDC score sheets and/or certificates. Dependent on the solicitation, contract, or purchase order, USDC may certify product under Type I (continuous inspection), Integrated Quality Assurance (IQA), HACCP, or lot inspection procedures. In addition, when required in the solicitation, contract, or purchase order, USDC inspectors will examine the salmon products for conformance to the United States Standards for Condition of Food Containers (7 CFR Part 42) and MIL-PRF-44073, Packaging of Food in Flexible Pouches, in effect on the date of the solicitation. (Note: For External Examination of pouches, use Table II and Table III and all footnotes. Inspection Level II, Major A Defects AQL 1.00, Major B Defects AQL 2.5, Minor Defects 4.00.)

**9.4 Product examination. FOR USDA PROCUREMENTS ONLY.** When required in the solicitation, contract, or purchase order, USDC shall conduct the following product examinations. All sampling for inspection and determination of acceptability shall be done in accordance with provisions set forth in the latest versions of the American National Standards Institute, ANSC/ASQC Z1.4. Defects found during inspection shall be classified in accordance with Tables II through VIII at the inspection levels acceptable quality levels (AQLs) as shown below. AQLs shall be expressed in defects per hundred units. The lot size shall be expressed in cans or pouches.

**TABLE II. Inspection levels and acceptance numbers**

Table	Inspection level <u>1/</u>	AQL	
		Major	Minor
III	S3	----	6.5
IV	S3	----	6.5
V	S3	----	10.0
VI	S3	----	6.5
VII	S3	1.5	6.5
VIII	S2	1.5	6.5

1/ Sample shipping containers shall be selected randomly on a proportionate basis from not less than 90 percent of the codes listed in a lot or on the warehouse receipts. In the event that the referenced levels result in a sample size that is too small to provide for sampling 90 percent of the codes in a lot or on the warehouse receipts a level sufficiently large to accommodate this requirement shall be selected. Not more than one primary container per shipping container shall be examined for the defects within the tables listed in Table II.

The sample unit for USDC Inspection is the contents of one can or pouch. For sampling purposes, the maximum lot size will be the quantity of product produced on a single line during an eight hour production shift. The lot size may be reduced by the USDC inspector if necessary.

If a plant operates two or more lines under inspection simultaneously, the products from each line will be inspected as separate lots. Also, if a plant wishes to extend the processing day beyond a normal eight hour shift, the product produced after the end of the eight hour shift will be inspected as a new lot. For labeling and identification purposes, production lots shall be numbered in sequence. For purposes of lot identification, in addition to the requirements contained in 21 CFR Part 113, a code change will be necessary when a shift concludes or a new shift begins.

Container integrity screening for canned salmon, when required, in the solicitation, contract or the purchase order, the manufacturer is required to perform container integrity screening for canned salmon.

For the purposes of Type II lot inspected product, a lot will consist of all codes from a single line produced during a normal eight hour shift.

For the purposes of Type I continuous inspection product, any facility which operates more than one line under inspection, it may be necessary to assign an inspector to each line. This is to enable the inspector to have sufficient time to perform a sanitation inspection, examination for product characteristics, condition of container examination, etc. and still have sufficient time to observe the materials being processed to ensure their suitability for processing.

The contractor shall obtain a USDC Certificate of Inspection or Lot Inspection Certificate which state(s) the product meets all requirements of this CID (applies to canned product or pouch salmon for the military).

**TABLE III. Examination for net weights and flesh percentages 1/ 2/ 3/ 4/**

Category	Defect
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**Minor**

201	A single primary container with more than 5 percent under the specified weight. <u>1/</u> <u>2/</u> <u>3/</u> (Style a, b, c).
202	Pouch contains less the 95 percent fish flesh (Style c only). <u>4/</u>

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1/ Failure of lot average net weight to meet specified net weight shall be basis for rejection of the entire lot.

2/ Report results to the nearest 0.1 g (0.004 oz).

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**3/** Net weight for canned, pouch, and fish flesh percentage for pouched product will be determined as follows:

Weigh sealed pouch.

Empty contents into a No. 20 sieve.

Allow the product in the sieve to drain for 2 minutes.

Clean and dry the pouch (as all bags are the same size and weight, this step needs to be performed on the first pouch in the sample only).

Weigh the empty pouch to determine the tare weight.

Deduct the weight of the empty pouch from the weight of the sealed pouch, and record as net weight.

Deduct the drained weight from the net weight and calculate the percent of fish flesh.

**4/** Failure of lot average to meet the specified 95 percent fish flesh requirement shall be basis for rejection of the entire lot.

**TABLE IV. Examination for vacuum requirements (canned product only)**

Category	Defect
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**Minor**

201	Vacuum less than 12.7 cm (5 in).
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**TABLE V Examination of pieces and patches (canned product only)**

Category	Defect
<b><u>Minor</u></b>	
201	Pink salmon only. More than 4 pieces and 1 patch in cans less than or equal to 454 g (16 oz). More than 12 pieces and 1 patch in 1,814 g (64 oz) cans. <b>1/</b>  All other canned salmon. More than 3 pieces and 1 patch in cans less than or equal to 454 g (16 oz). More than 12 pieces and 1 patch in 1,814 g (64 oz) cans. <b>1/</b>

**1/** A patch is a small portion of salmon which is added, if necessary, to complete the fill of the container. A patch is any small portion less than 28 g (1 oz).

**TABLE VI. Product defects**

Category		Defect
<u>Critical</u>	<u>Major</u>	<u>Minor</u>
1		Flesh showing evidence of true honeycombing or the presence of flavors and/or odors of decomposition such as, but not limited to, sour and rancid, or other flavors and odors of decomposition. <u>1/ 2/</u>
2		Presence of chemicals, glass, or metal particles, animal excreta, struvite crystals or similar extraneous material which could harmfully affect or contaminate the product. <u>1/</u>
	101	Presence of objectionable flavors or odors such as, but not limited to, burnt, scorched, overcooked, stale, or other objectionable flavors or odors, or flavors or odors of watermarking (hominy, muddy). <u>3/</u>
	102	Presence of objectionable foreign materials such as, but not limited to rust, wood, hair, dirt, or insects or insect parts either singly or in combination.
	103	Bones hard, not soft and friable. <u>4/</u>
	104	Species of salmon not as specified.
	105	Evidence of freezing and/or slacking (thawing) as indicated by the presence of more than a moderate amount of curd or other factors (canned products only).
	106	Pouch salmon not produced from deep skinned salmon fillets (Style c only).
	201	Presence of watermarking indicated by the color change of the normal white area (i.e., belly) to another color characteristic of the species (Style a only).
	202	Presence of gills, fins, or viscera.

TABLE VI. Product defects (continued)

Category	Defect
<u>Critical</u>	
<u>Major</u>	
<u>Minor</u>	
	203 Color of flesh not characteristic of species.
	204 Color of oil not characteristic of species.
	205 Texture of fish not characteristic of species.
	206 Presence of skin and backbone (Style b only). <u>5/</u>
	207 Presence of skin (not deep skinned) or bone (Style c only).
	208 Presence of blood clots, mutilated areas, or bruises. <u>6/</u>
	209 Sulfide blackening (canned product only).

1/ These are regarded as critical defects and their finding will be basis for rejection of the entire lot.

2/ Honeycombing is the visible appearance of discrete holes or openings of varying size, observed in salmon flesh.

3/ Do not include flavors and odors of decomposition.

4/ Hard bones are those which are not soft or friable. Bones are soft and friable if the vertebrae are easily crushed when pressed between thumb and fingers. Bones should be brittle and breakable with slight distorting finger pressure. Thermal processing records should be carefully reviewed and process authorities should be consulted if necessary.

5/ Minor 206 is a defect if the skin and backbone is not removed in accordance with good manufacturing practices. If the majority of sample units are defects, the lot may be relabeled as Style a.

6/ Mutilated areas are areas of flesh which are not physically intact due to mechanical or predatory damage. Blood clots or bruises are those, which detract from the appearance of the

product. Minute blood streaks or blood spots that do not materially affect the appearance are not a defect.

**TABLE VII Can interior enamel coating defects (canned product only)**

Category	Defect
<b><u>Major</u></b>	<b><u>Minor</u></b>
101	Missing enamel coating.
102	Blistered or softened enamel coating, which can be peeled by fingertip (not fingernail abrasion).
103	Enamel coating with internal rust stains.
201	Enamel coating with bare areas (other than scratches).
202	Enamel coating that is dirty, stained or smeared with foreign material.

**Testing for salt content or sodium content.** The composite for testing for salt content or sodium content shall be a composite of 680 g (24 oz) of product. The minimum number of sample units to use for deriving the composite for salt or sodium content is twelve sample units. The sample units shall represent all the codes selected for product evaluation. Equal amounts of product will be taken from each selected sample unit and from each code. If the sample size is too small to provide for sampling all codes, more sample units may be selected with less product taken from each can.

At least two tests from a composite sample shall be performed and the results averaged. The test results for salt shall be reported to the nearest 0.1 percent and sodium shall be reported to the nearest mg per 100 g.

Failure to meet salt/sodium levels specified in the solicitation, contract, purchase order, or CID shall be basis for rejection of the entire lot.

**10. PACKAGING.** Preservation, packaging, packing, labeling, and case marking shall be commercial unless otherwise specified in the solicitation, contract, or purchase order.

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**11. USDC INSPECTION NOTES.** When 9.3 is specified in the solicitation, contract, or purchase order, USDC certification shall include evaluation of the quality and condition of samples of packaged salmon products, and compliance with requirements in the following areas:

- Salient characteristics (Sec. 5).
- Analytical requirements *when specified in the solicitation, contract, or purchase order* (Sec. 6.2). When USDC analytical testing is specified, USDC inspection personnel shall select samples and submit them to the National Analytical Services, Seafood Inspection Program for analysis.
- Packaging requirements (Sec. 10 or as specified in the solicitation, contract, or purchase order).

**12. REFERENCE NOTES.**

**12.1 USDC certification contact.** For USDC certification, contact the nearest USDC Seafood Inspection Region Office listed below.

**Northeast Region Inspection Office**  
NOAA Fisheries  
11-15 Parker Street  
Gloucester, MA 01930  
Telephone 978-281-9228  
Fax 978-281-9134, 978-281-9125

**Southeast Region Inspection Office**  
NOAA Fisheries  
9721 Executive Center Drive N., Suite 133  
Koger Building  
St. Petersburg, FL 33702  
Telephone 727-570-5383  
Fax 727-570-5387

**Western Region Inspection Office**  
NOAA Fisheries  
Building 32, Room 286A  
7600 Sand Point Way N.E.  
Seattle, WA 98115-6349  
Telephone 206-526-4259  
Fax 206-526-4265

**12.2 Analytical testing and technical information.** For USDC technical information on analytical testing, contact the **National Analytical Services, USDC Seafood Inspection Program, 11-15 Parker Street, Gloucester, MA 01930, telephone (978) 281-9386, or via E-mail: Jane.E.Fox-Dobson@noaa.gov.**

**12.3 Sources of documents.**

**12.3.1 Sources of information for nongovernmental documents are as follows:**

Copies of the Official Methods of Analysis of the AOAC International, either printed or on CD-ROM versions, may be obtained from: **AOAC International, 481 North Frederick Avenue, Suite 500, Gaithersburg, MD 20877, telephone (301) 924-7077. Internet address: [www.aoac.org](http://www.aoac.org).**

Copies of the latest version of ANSC/ASQC Z1.4 Sampling Procedures and Tables for Inspection by Attributes, may be obtained from: **American Society for Quality, 600 North Plankinton Avenue, Milwaukee, WI 53201, telephone (800) 248-1946. Internet address: [www.asq.org](http://www.asq.org).**

**12.3.2 Sources of information for governmental documents are as follows:**

Applicable provisions of the Fair Packaging and Labeling Act are contained in 16 CFR Parts 500 to 503 and the Federal Food, Drug, and Cosmetic Act are contained in 21 CFR Parts 1 to 199. These documents may be purchased from: **Superintendent of Documents, ATTN: New Orders, P.O. Box 371954, Pittsburgh, PA 15250-7954. Credit card (MasterCard or Visa) purchases may be made by calling the Superintendent of Documents on (202) 512-1803 or on the Internet at: <http://www.nara.gov/fedreg>.**

Copies of FDA, Center for Food Safety and Applied Nutrition, Fish and Fisheries Products Hazards and Controls Guidance are available on the Internet at: <http://www.cfsan.fda.gov/~comm/haccp4.html>.

Copies of “USDC Participants List for Firms, Facilities and Products” or other information regarding policy and procedures of the USDC Seafood Inspection Program are available from: **U.S. Department of Commerce, National Oceanic and Atmospheric Administration, Seafood Inspection Program, Documentation Approval and Supply Services Section, P.O. Drawer 1207, Pascagoula, MS 39568-1207, telephone (228) 762-1892, Fax (228) 769-1436, or on the Internet at: <http://seafood.nmfs.noaa.gov/publications.htm>.**

Copies of this CID and the United States Standards for Condition of Food Containers are available from: **Head, Food Quality Assurance Staff, FVP, AMS, USDA, STOP 0243, 1400 Independence Ave., SW, Washington, DC 20250-0243, telephone (202) 720-9939, Fax (202) 690-0102, via E-mail: [FQAStaff@usda.gov](mailto:FQAStaff@usda.gov) or on the Internet at: <http://www.ams.usda.gov/fv/fvqual.htm>.**

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Beneficial comments, recommendations, additions, deletions, clarifications, etc., and any data which may improve this document should be sent to: **Technical Services Branch, Seafood Inspection Program, U.S. Department of Commerce, Room 10874, 1315 East-West Highway, Silver Spring, MD 20910-3282, telephone (301) 713-2355, Fax (301) 713-1081, or via E-mail: [Kenneth.Aadsen@noaa.gov](mailto:Kenneth.Aadsen@noaa.gov).**

Military activities may obtain copies of this CID and MIL-PRF-44073 from: **Standardization Documents Order Desk, Document Automation and Production Service, 700 Robbins Avenue, Building 4D, Philadelphia, PA 19111-5094 or on the Internet at: <http://assist.daps.dla.mil/quicksearch/> or [www.dodssp.daps.mil](http://www.dodssp.daps.mil).**

### MILITARY INTERESTS:

#### Military Coordinating Activity

Army - GL

#### Custodians

Army - GL

Navy - SA

Air Force - 35

### CIVIL AGENCY COORDINATING ACTIVITIES:

DOJ - BOP

HHS - NIH, IHS

USDA - FV

VA - OSS

DOC - NOAA

### PREPARING ACTIVITY:

DOC - NOAA

### Review Activities

Army - MD, QM

Navy - MC

DLA - SS

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